

Work Order ID 61095

August 6, 2010 8:42:14 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4102-2

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 06/08/2010 Start Qty: 1.00



Cust Item ID:



Required Date: 09/08/2010 Req'd Qty: 1.00

Customer:

Reference:

Jeff 10.08.06

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4102	REV.PRELIM <i>PB2</i>								

100	Cut blanks as per folio	0.00							
Bandsaw	Memo	0.00	<i>L.F 10/08/09</i>	<i>1</i>	<i>0</i>				
Jeaspa Bandsaw	4.950" long								

110		0.00							
HAAS 1	Memo	0.00	<i>L.F 10/08/09</i>	<i>1</i>	<i>0</i>				
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA945 FOLIO REV: <i>AA</i> DWG REV: <i>PB2</i> DEBURR								

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Item ID:	D4102-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Shim					
Start Date:	06/08/2010	Start Qty:	1.00			
Required Date:	09/08/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo <input type="checkbox"/>	0.00 0.00				1	7		
			Jul 10. 08. 01						
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
			- inspect to BODY only 8/10/08 (K)						
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
			ml 10 08 10 (i)						

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Item ID:	D4102-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Shim					
Start Date:	06/08/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	09/08/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo DAVID SHEPHERD	0.00 0.00		10/8/10 S					
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 08/06 AUTH W

RELEASED _____ DATE _____

ME
10-8-10

Picklist Print

Page 1

August 6, 2010 8:42:14 AM

Work Order ID: 61095



Parent Item: D4102-2



Parent Item Name: Shim

Start Date: 06/08/2010

Required Date: 09/08/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No				f	16.2347	0.042	0.044211			



6061-T6 Bar .250 x 4.00

Location

Loc Qty

Loc Code

MAT

16.234734

110680

0.279156

114608

15.955578

0443 88 10/08/09

DART AEROSPACE LTD		Work Order: 61095
Description: SHIM		Part Number: 24102-2
Inspection Dwg: 4102	Rev: PB2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.356	±.010	.355	✓		SP-72	
.490	"	.494	✓		vern	
.965	"	.964	✓		vern	
1.344	"	1.343	✓		vern	
2.587	"	2.589	✓		vern	
3.325	"	3.323	✓		vern	
3.370	"	3.374	✓		vern	
3.505	"	3.510	✓		vern	
3.574	"	3.577	✓		vern	
4.00	±.030	4.03	✓		vern	
4.75	"	4.753	✓		vern	
4.234	±.010	4.236	✓		vern	
3.940	"	3.943	✓		vern	
3.770	"	3.772	✓		vern	
3.418	"	3.420	✓		vern	
2.315	"	2.314	✓		vern	
2.290	"	2.294	✓		vern	
1.534	"	1.523	✓		vern	
1.125	"	1.125	✓		vern	
.718	"	.719	✓		vern	
.600	"	.604	✓		vern	
.213	±.010	.211	✓		vern	
Ø.129	±.005 ±.001	.129	✓		SF-12	

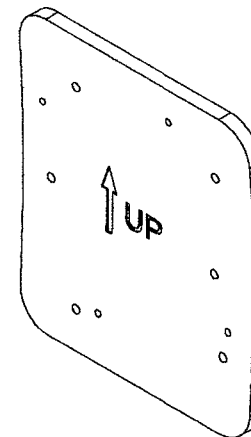
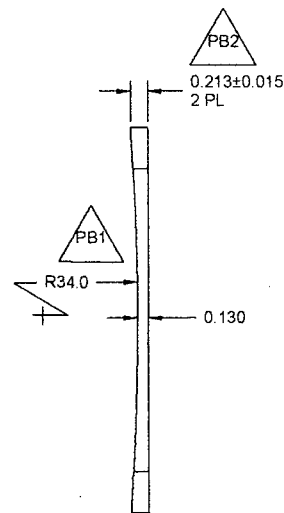
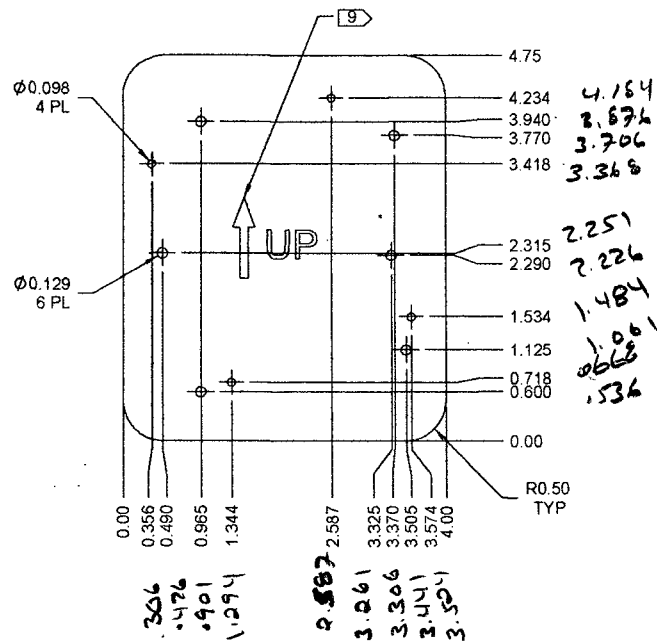
Measured by: <i>SP</i>
Date: 10/04/01

Audited by: <i>S</i>
Date: 10/05/10

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4102-2 SHIM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
PER DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4102-2" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.29 lbs
- 8) SURFACE FINISH MINIMUM 250 MICROINCH
- 9) ENGRAVE "UP & ARROW" TO A DEPTH OF MAXIMUM 0.020 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.063

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB
MFG APPR.		D4102	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Kim Johnston

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, August 12, 2010 12:24 PM
To: 'Kim Johnston'
Subject: RE: three more prelim work orders

Kim,

Yes ... These parts will also be scrapped after testing.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Thursday, August 12, 2010 5:48 AM
To: David Shepherd
Subject: three more prelim work orders

Hi David,

I have three more prelim work orders, D4102-1 B61093, D4102-2 B61095 and D4102-3 B61096. Have they also been sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after.
I'll attach your email to the work orders and file them. Thanks,

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: kjohnston@dartaero.com
Tel: 613-632-5200
Fax: 613-632-9311

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Checked by AVG - www.avg.com

Version: 8.5.441 / Virus Database: 271.1.1/3066 - Release Date: 08/12/10 06:34:00